

Split
Work Order ID 71654-2

Thursday, July 07, 2011 12:06:35 PM



Page 1

Item ID: D3256-1

Accept

Revision ID:

Item Name: Panel

6

Start Date: 7/7/2011 Start Qty: 6.00



Required Date: 7/21/2011 Req'd Qty: 6.00



Reference:

Approvals: Process Plan: *CJ*

Date: 11/07/07

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D3256

Rev C

0.00

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

304 - 032

Memo

I-Cut as per Dwg D3256
Dwg Rev: *C*
Prog Rev: *C*
2-Deburr if necessary

RSH-8-10

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

RSH-9-10

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

S WOS 111

(7)

Work Order ID 71654

Thursday, July 07, 2011 12:06:35 PM



Page 2

Item ID: D3256-1

Accept



Setup

Start



Revision ID:

Item Name: Panel

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

80 11/12/22

GJ.
Q

Brake NC

Memo

0.00

Brake NC

Form using D3256-1T2

140



QC5- Inspect part completeness to step on W/O

0.00

50 11/12/22

(+6)

QC

Memo

0.00

Quality Control

150



Identify as per dwg & Stock Location 178

0.00

11/12/22 SP (6)

Packaging

Memo

0.00

Packaging

Work Order ID 71654

Thursday, July 07, 2011 12:06:35 PM



Page 3

Item ID: D3256-1

Accept



Setup Start



Revision ID:

Item Name: Panel

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo

11/12/22 JH
MF 11-12-22

Picklist Print

Thursday, July 07, 2011 12:06:33 PM

Page 1

Work Order ID: 71654



Parent Item: D3256-1



Parent Item Name: Panel

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 		Purchased	No			100	sf	43.3600	0.987	6.233684	7		

304/316 .032 Sheet

Location	Loc Qty	Loc Code
020	5.8	
109057	5.8	
MAT020	37.56	
117379	37.56	W91606
W91606		

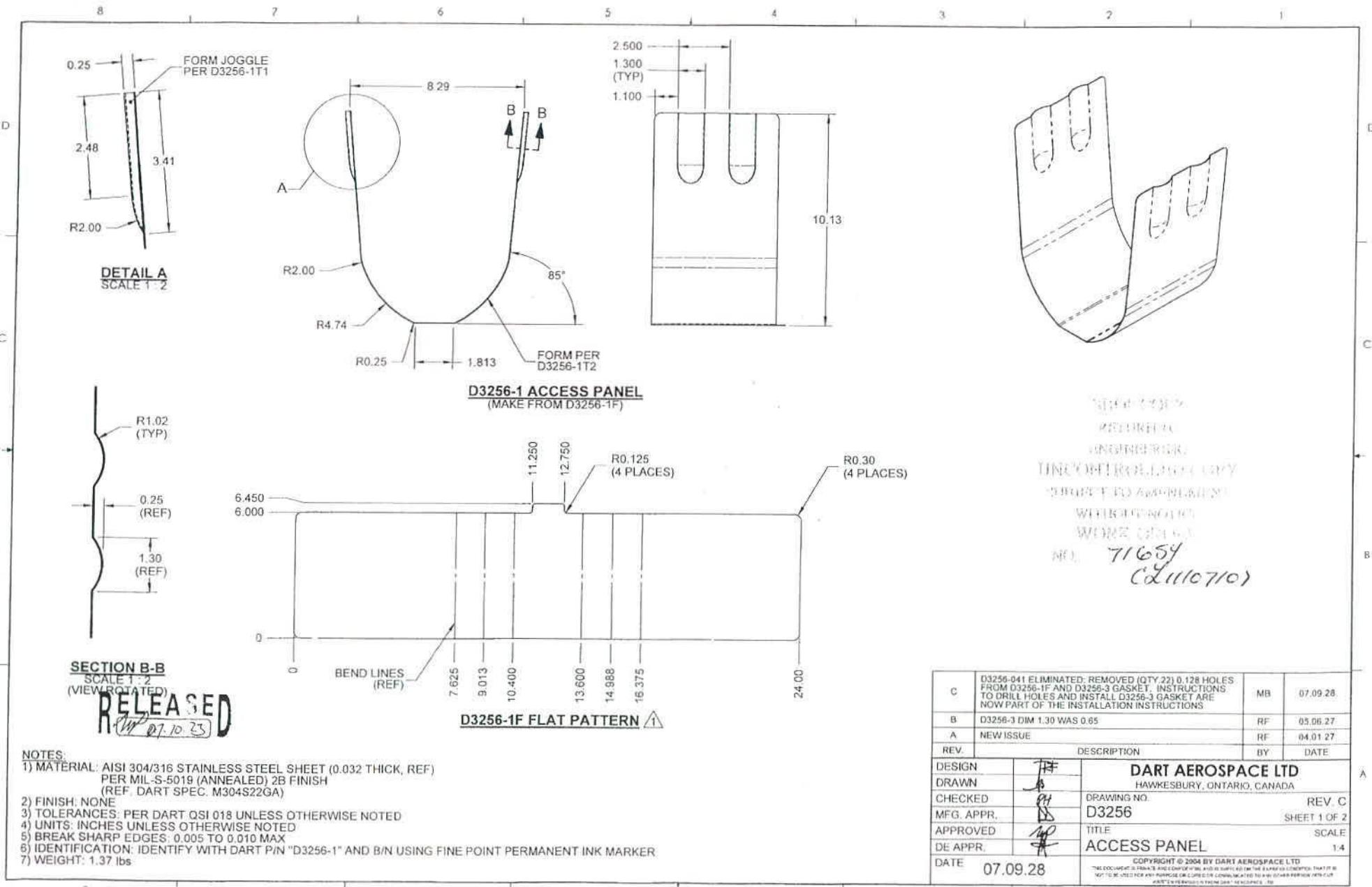
DART AEROSPACE LTD	Work Order:	71654
Description: Access Panel Assembly	Part Number:	D3256-1
Inspection Dwg: D3256 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	1-8-10	Date:	W/08/10	Date:	N/A

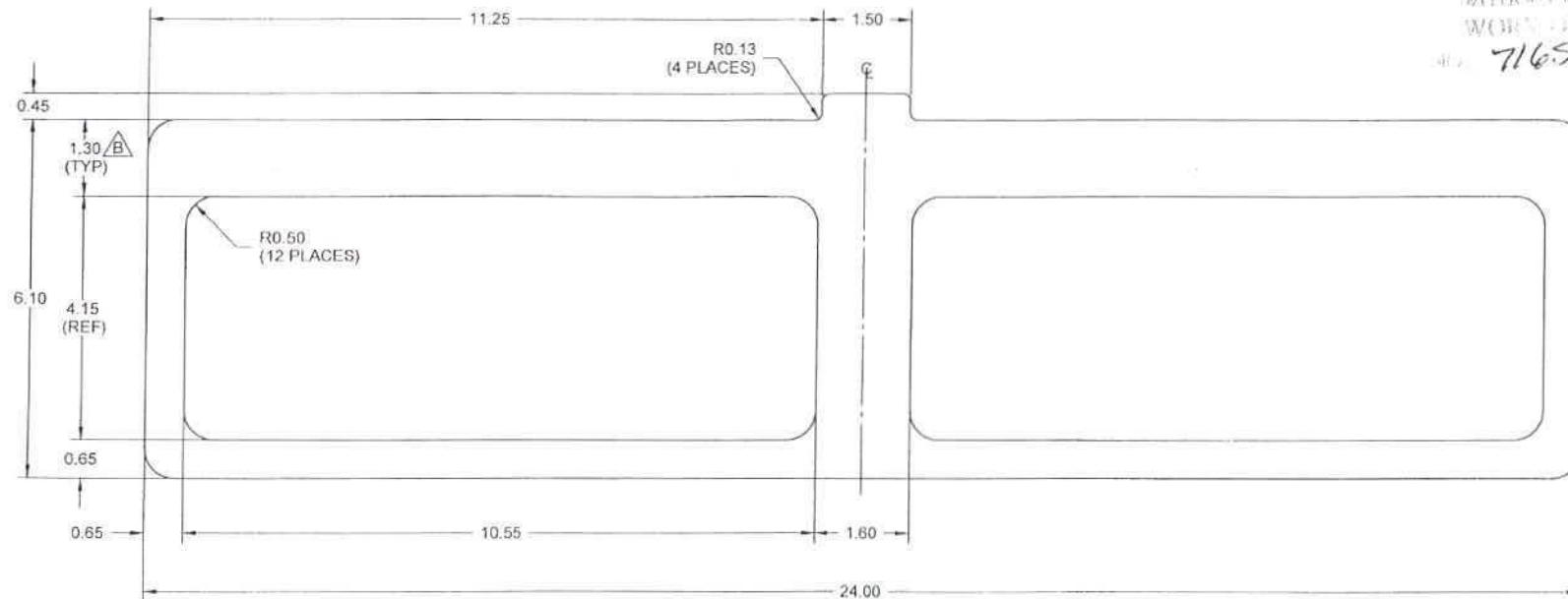
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3256-041	KJ/JLM	
B	08.09.04	Dimensions removed	KJ/DD	



8 7 6 5 4 3 2 1

D

D

D3256-3 ACCESS PANEL**RELEASED**
(07-10-03)

A

A

NOTES:

- 1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK PER MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2)
OR MIL-G-12803A (GRADE P-1161A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

A

DESIGN	<i>JF</i>	DART AEROSPACE LTD
DRAWN	<i>JF</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO.
MFG. APPR.	<i>DS</i>	REV. C
APPROVED	<i>MF</i>	D3256
DE APPR.	<i>MF</i>	SHEET 2 OF 2
DATE	<i>07.09.28</i>	TITLE
		SCALE
		1.2
		ACCESS PANEL
		COPYRIGHT © 2004 BY DART AEROSPACE LTD
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ONLY FOR EXPRESS CONTRACT PURPOSES. IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THE CONTRACT AGREEMENT UNLESS APPROVED BY OTHER PERSONNEL AT DART.

8 7 6 5 4 3 2 1